

Monday, March 27, 2017 3:55:10 PM

Item ID: D350-567-111B

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Super-Sized Vertical Reference Floor Window (Blank)

Start Date: 3/31/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/3/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: SCHEDULED/C

Run Start

NR1

Approvals: Process Plan: CM Date: MAR 27 2017 Tooling:

Date:

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9637	A	MAR 28 2017						DAS 21 9-89	17 03-29
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-111b		CHG002						
						DAS 27 9-89			
									APR 06 2017
110	Pick Kit	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging									
						DAS 6 9-89		DAS 28 9-89	
									APR 06 2017
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									
						DAS 27 9-89			

APR 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Work Order ID 158598

Monday, March 27, 2017 3:55:10 PM

158598

Page 2

Item ID: D350-567-111B Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Super-Sized Vertical Reference Floor Window (Blank)
Start Date: 3/31/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-111b								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS 27 9-89
APR 06 2017
DAS 21 9-89
APR 06 2017
DAS 21 9-89
APR 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 1

Monday, March 27, 2017 3:55:15 PM

Work Order ID: 158598

158598

Parent Item: D350-567-111B

D350-567-111R

Parent Item Name: Super-Sized Vertical Reference Floor Window (Blank)

Start Date: 3/31/2017

Required Date: 4/3/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.16 NEW ISSUE DD VERF:JLM
16.04.25 as per chg002 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-567-113		Manufactured	No			110	Each	2.0000	1	1			
D350-567-113									**				
Replacement Exterior Super-sized Window													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG033		2							
				157196		2							
D350-567-115B		Manufactured	No			110	Each	0.0000	1	1			
D350-567-115R									**				
Interior Floor Window, Blank													

DAS
27
9-89

DAS
28
9-89

DAS
27
9-89

DAS
27
9-89

158599 12/03/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1

REF. TCCA STC: SH92-18

REF. FAA STC: SH989NE AND SH990NE

REF. EASA STC: EASA.IM.R.S.01560 AND EASA.IM.R.S.01561

1.0 PURPOSE

This service instruction is intended for customers wishing to upgrade their existing OEM small vertical reference window kit to a DART D350-567-111 Floor Window Kit. Since the DART D350-567-115 Floor Window Kit included with D350-567-111 does not share the same rivet patterns as the OEM kit, the D350-567-111B/-115B Kits from this service instruction replaces the D350-567-111/-115 Kits to facilitate installation without having to perform extensive rework/repair of the aircraft floor prior to installation.

2.0 INSTALLATION OF D350-567-111B:

Note: With reference to Installation Instructions D350-567, make the following substitutions:

- D3293-1B replaces D3293-1;
- D3294-1B replaces D3294-1;
- D3295-041B replaces D3295-041;
- D3296-041B replaces D3296-041.

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WORK ORDER
NO. 158598

MAR 27 2017

- 2.1 Perform Step 3.3.1 of Installation Instructions D350-567 as required.
- 2.2 Locate the D3293-1B per Figure 1 of this service instruction.
- 2.3 Enlarge the viewing hole in the aircraft floor by using D3293-1B as template.
- 2.4 Transfer drill $\varnothing 0.128$ " holes from the aircraft floor to D3293-1B Doubler, D3294-1B Bracket, and D3295-041B Window. Drill additional holes as required through D3293-1B and aircraft floor. Ensure minimum pitch and edge distance as indicated.
- 2.5 Enlarge existing $\varnothing 0.128$ " holes to $\varnothing 0.141$ " as required and drill qty(4) $\varnothing 0.141$ " as shown in Figure 1 of this service instruction for a total of qty(9) $\varnothing 0.141$ " holes.
- 2.6 Locate D3296-041B and transfer drill qty(12) $\varnothing 0.128$ " and qty(3) $\varnothing 0.141$ " holes from the D3293-1B Doubler/aircraft floor to the blank hinge blade of D3296-041B.
- 2.7 Complete installation in accordance with Section 3.3 of Installation Instructions D350-567.
- 2.8 Touch up finish on drilled parts in accordance with Section 5.1.3 of ICA-D350-567.
- 2.9 Install the D350-567-113 Kit per Section 3.7 of D350-567. No changes.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 12.11.16
CERT. NO.: SH92-18
ISSUE NO.: 6

A	NEW ISSUE	MB	12.11.15
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9637	SHEET 1 OF 4
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3.0 PARTS LIST

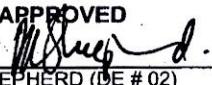
QTY -111B	QTY -113	QTY -115B	Part Number	Description
X			D350-567-111B	FLOOR WINDOW INSTALLATION, EXTRA LARGE (BLANK)
1	X		D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
1		X	D350-567-115B	INTERIOR FLOOR WINDOW KIT (BLANK)
	1		D2463-0860	NEOPRENE SEAL
	1		D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
	12		2600-6	1/4 TURN FASTENER
	12		2600-LW	WASHER
	12		212-12	RECEPTACLE
	21		AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	42		AN960JD8	WASHER
	21		MS21042L08	NUT (OR MS21042-08)
	24		MS20426AD3-5	RIVET
	2 SQ. YD		N/A	9.7 OZ 7781 'S' GLASS UNIVERESAL WEAVE
		1	D3293-1B	DOUBLER, BLANK
		1	D3294-1B	BRACKET, BLANK
		1	D3295-041B	FLOOR WINDOW, BLANK
		1	D3296-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
		1	D2463-0530	NEOPRENE SEAL
		9	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	AN960JD6	WASHER
		9	MS21042L06	NUT (OR MS21042-06)
		2	MS20470AD4-5	RIVET
		115	MS20470AD4-6	RIVET
		15	MS20470AD4-7	RIVET

4.0 WEIGHT AND BALANCE

For D350-567-111B, use the weight and balance information for D350-567-111..

5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS

Maintenance and continued airworthiness instructions for D350-567-111B is the same as for D350-567-111. Refer to ICA-D350-567.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 12.11.16	
CERT. NO.: SH92-18	
ISSUE NO.: 6	

DESIGN		DART AEROSPACE LTD	
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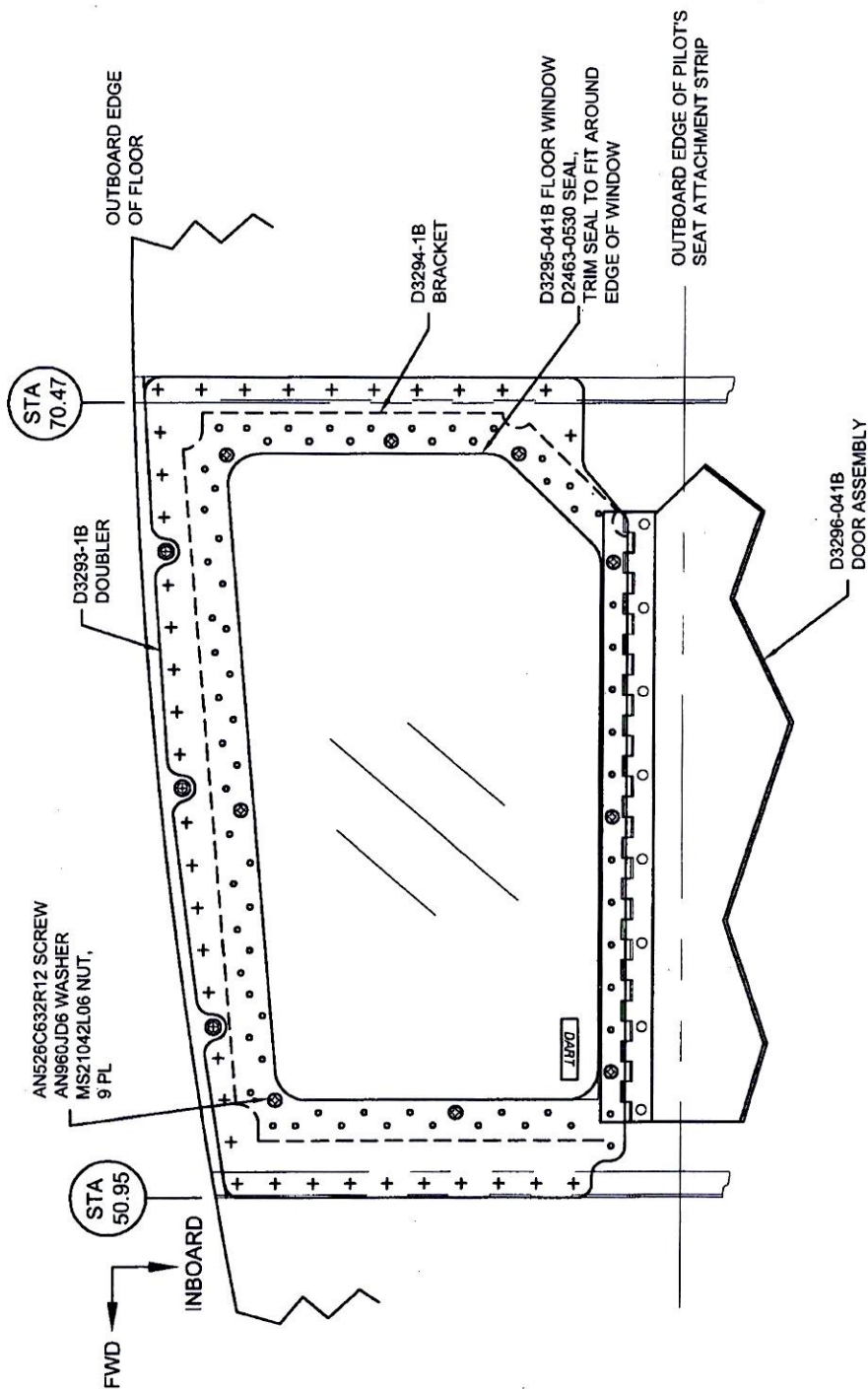


FIGURE 1: D350-567-115B KIT OVERVIEW
(SLIDING DOOR MOD NOT SHOWN)

CANADA
DEPARTMENT OF TRANSPORT
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BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

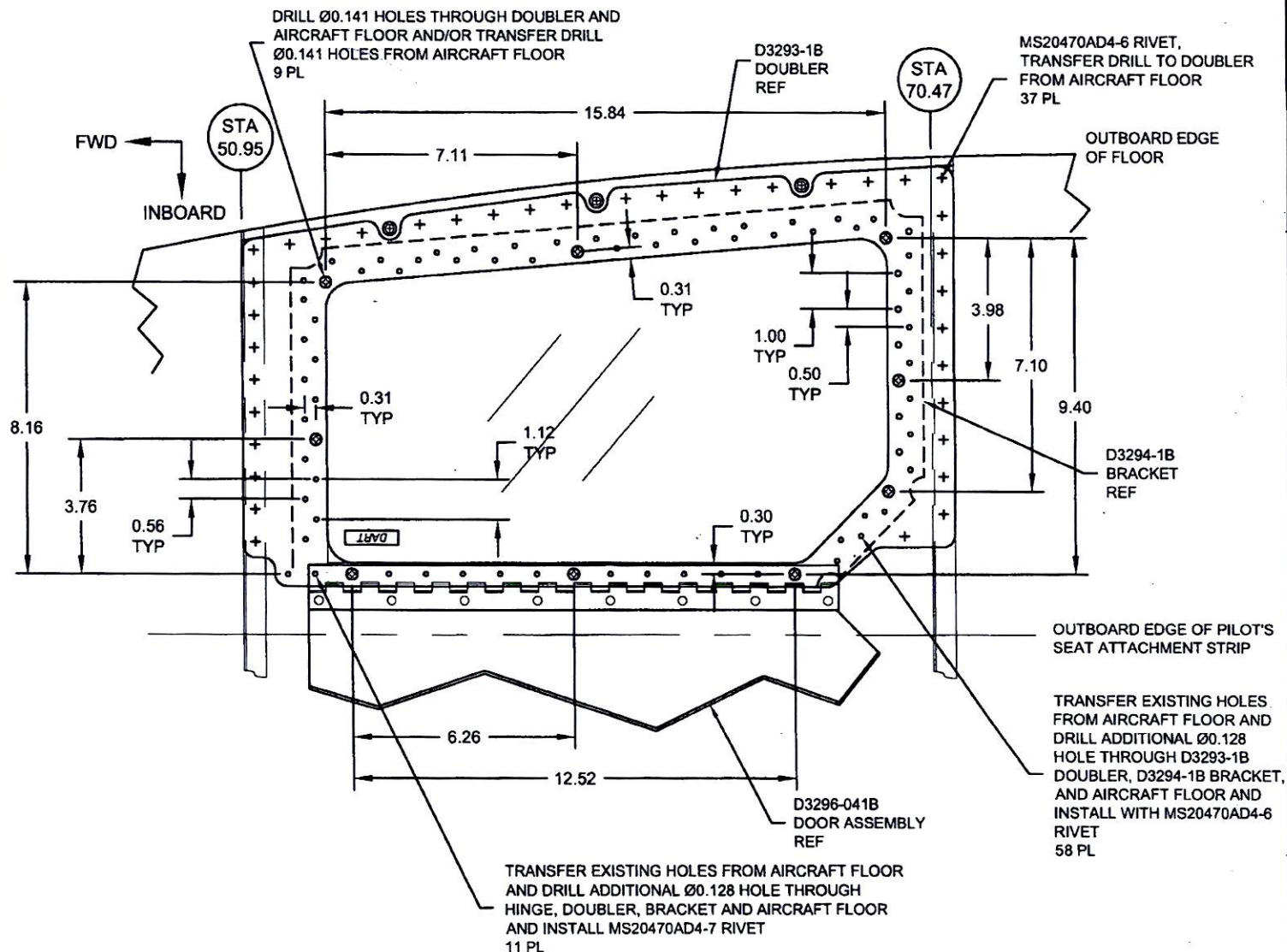
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D. SHEPHERD (DE # 02)

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**FIGURE 2: TYPICAL PITCHES FOR
ADDITIONAL REQUIRED RIVETS**
(SLIDING DOOR MOD NOT SHOWN)

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